

Date: Monday, 5/15/2006 11:10:36 AM
 User: Kim Johnston

Process Sheet

Split
DB 06/06/13

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 27102-2					
Estimate Number	: 11036					
P.O. Number	: N/A			Part Number	: D2804041	
This Issue	: 5/15/2006 S.O. No. : N/A			Drawing Number	: D2804 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: 5/15/2006 Type : R & D SM/MED FAB			Drawing Revision	: B	
Previous Run	: 25919			Material	: N/A	
Written By	: <i>Sgt</i> (COMMENT BELOW)			Due Date	: 6/5/2006	
Checked & Approved By	: <i>Sgt</i> 06.05.15			Qty:	20	Um: Each
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3			KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28041	STA 155 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) STA 155 Bracket Pick: Qty Part Number Description Batch 1 D2804-1 Bracket <i>B27112</i>	
2.0	D28051	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Stop Pick: Qty Part Number Description Batch 1 D2805-1 Stop <i>B27304 4 B25931 16 M.F. 06/06/13</i>	
3.0 <i>9.1</i>	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 1 D2809 Bushing <i>B27306 x 13 B25959 x 17 FF 06.06.14</i>	
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2804 <i>m.F. 06/06/08</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:10:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/07

20

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/12

20

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SD 06/06/13

20

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2804

FF 06.06.13

PTO
28

9.0 AN3C16A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	119944 x 36
			0710164 x 4

FF 06.06.13

18

10.0 MS210433 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	1100210

FF 06.06.13

18

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
			4 NAS1515H3

Washer M19633

18

A/R

LPS-3

Corrosion Spray

117045

FF 06.06.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-13	8	1JD2809 over pressed	<i>JB</i> <i>GDH</i>	Taken out of bracket and Destroyed	06-06-13 FF	<i>JB</i> 06-06-13	<i>JB</i> 06-06-13	<i>JB</i> 06-06-13

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 06/06/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 5/15/2006 11:10:36 AM
User: Kirk Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27102

Part Number: D2804041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

FF 06.06.14

12

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 06.06.14

13

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STNS8

AP 06.06.14 (18)

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/16

(18)

Job Completion



U 06.06.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

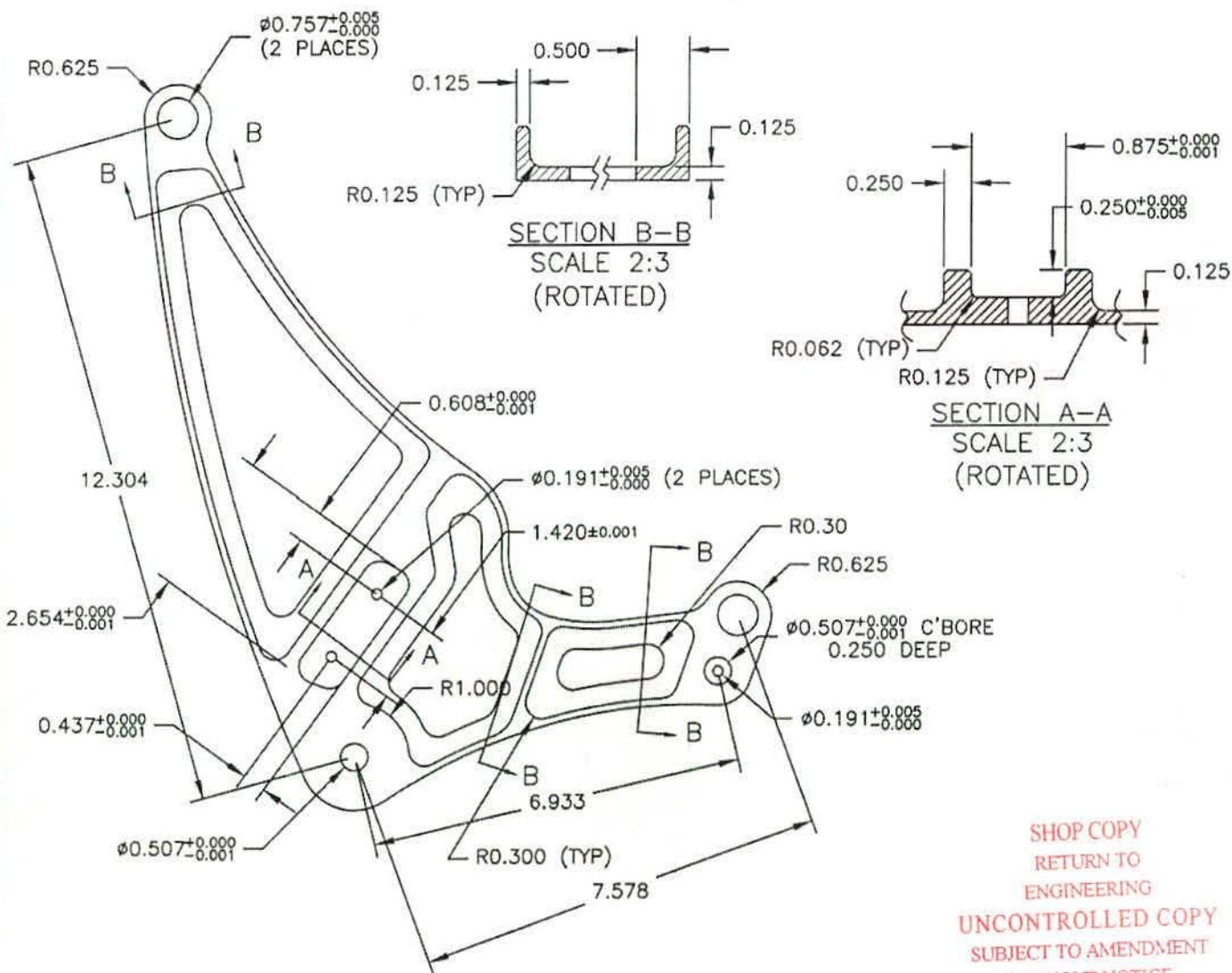
QA: N/C Closed: _____ Date: _____

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 ~~+~~



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27102

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

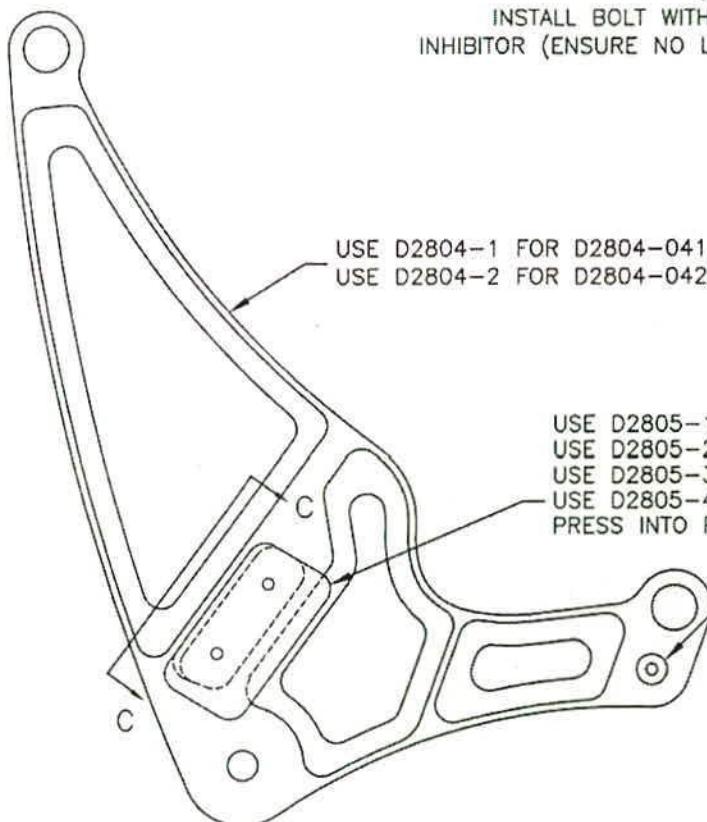
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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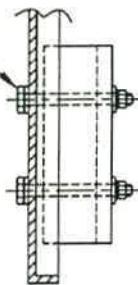
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>11</i>	APPROVED <i>11</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3



AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

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RELEASED
05.03.11 *11* NO. 27102 WORK ORDER

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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